



Dart Aerospace Ltd.
1270 Aberdeen St
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K6A 1K7
Canada

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D4776-3

Job Sheet 200413



Part No: D4776-3

Job Qty: 20 pcs

Part Name: Skidtube Clevis



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 9/11/19

Job Tracking No:

Created By: Marie Lajeunesse

Due Date: 10/2/19

Description:

Note: DWG D4776 REV.E IPP REV A: NEW ISSUE JFS 13/03/07 VERIFY BY: JLM IPP REV:B 13.09.26 AS PER
REV.B DD VERF:JLM IPP REV:C AS PER REV. PC1 JFS 13/11/07 VERIFY BY: JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Bandsaw - 1	20 pcs	10/2/19	10/2/19	0.00	0.36	Bandsaw - 1		BN 19-10-28
110	HAAS 4 Axis - B4B	20 pcs	10/2/19	10/2/19	0.26	17.39	HAAS - 1 - B4B		JML 19/11/03
							HAAS - 2 - B4B		
							HAAS - 3 - B4B		
							HAAS - 4 - B4B		
120	QC 2	20 pcs	10/2/19	10/2/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		JML 19/11/03
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		



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Container No: S227662



Part: D4776-3

Job No: 200413

Serial No/Batch: S227662

Revision: E

Inspector:

Print Date:

Instructions: Various STC's

Date: 10/29/19

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130 QC 8	20 pcs	10/2/19	0.00	0.00	QC 2 - 63	
					QC 2 - 8	
					QC 2 - 66	
					QC 2 - 64	
					QC 2 - 65	
					QC 2 - 5	
					QC 2 - 71	
					QC 2 - 73	
					QC 2 - 69	
					QC 8 - 12	
					QC 8 - 14	
					QC 8 - 17	
					QC 8 - 20	19-11-03
					QC 8 - 25	
					QC 8 - 3	
					QC 8 - 32	
					QC 8 - 33	
					QC 8 - 35	
					QC 8 - 39	
					QC 8 - 4	
					QC 8 - 44	
					QC 8 - 45	
					QC 8 - 49	
					QC 8 - 58	
					QC 8 - 8	
					QC 8 - 9	
					QC 8 - 68	
					QC 8 - 67	
					QC 8 - 1 (A)	
					QC 8 - 47	
					QC 8 - 40	
					QC 8 - 52	
					QC 8 - 23	
					QC 8 - 57	
					QC 8 - 76	
140 Handfinish - 1-1 Chemical-B4B	20 pcs	10/2/19	0.00	0.53	Handfinish - 1 - 1 - B4B	
					Handfinish - 1 - 2 - B4B	
					Handfinish - 1 - 3 - B4B	NOV 05 2019
					Handfinish - 1 - 4 - B4B	
					Handfinish - 1 - 5 - B4B	
					Handfinish - 1 - 6 - B4B	
					Handfinish - 1 - 7 - B4B	
					Handfinish - 1 - 8 - B4B	
					Handfinish - 1 - 9 - B4B	
					Handfinish - 1 - 10 - B4B	
					Handfinish - 1 - 11 - B4B	
					Handfinish - 1 - 12 - B4B	
					Handfinish - 1 - 13 - B4B	

						Handfinish - 1 - 14 - B4B	
						Handfinish - 1 - 15 - B4B	
						Handfinish - 1 - 16 - B4B	
						Handfinish - 1 - 17 - B4B	
						Handfinish - 1 - 18 - B4B	
						Handfinish - 1 - 19 - B4B	
						Handfinish - 1 - 20 - B4B	
						Handfinish - 1 - 21 - B4B	
						Handfinish - 1 - 22 - B4B	
150	QC 7	20 pcs	10/2/19	0.00	0.00	QC 7 - 10	
						QC 7 - 13	
						QC 7 - 14	
						QC 7 - 15	
						QC 7 - 17	
						QC 7 - 18	
						QC 7 - 19	
						QC 7 - 2	
						QC 7 - 28	
						QC 7 - 3	
						QC 7 - 30	
						QC 7 - 34	
						QC 7 - 36	
						QC 7 - 37	
						QC 7 - 41	
						QC 7 - 47	
						QC 7 - 48	
						QC 7 - 51	
						QC 7 - 58	
						QC 7 - 59	
						QC 7 - 60	
						QC 7 - 9	
						QC 7 - 68	
						QC 7 - 50	
						QC 7 - 67	
						QC 7 - 40	
						QC 7 - 24	
						QC 7 - 43	
						QC 7 - 61	
						QC 7 - 81	
						QC 7 - 76	
160	Powdercoat - 1 White GI(A)- B4B	20 pcs	10/2/19	0.00	0.24	Powdercoat - 1 - B4B	
						Powdercoat - 2 - B4B	
						Powdercoat - 3 - B4B	
						Powdercoat - 4 - B4B	
170	QC 3	20 pcs	10/2/19	0.00	0.00	QC 3 - 10	
						QC 3 - 13	
						QC 3 - 15	
						QC 3 - 17	
						QC 3 - 18	
						QC 3 - 2	
						QC 3 - 28	
						QC 3 - 3	

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Bl 19-11-6.

M211886.

START: 0.50

OV.T: 320° FINISH: 11:20

					QC 3 - 30	
					QC 3 - 34	
					QC 3 - 36	
					QC 3 - 41	
					QC 3 - 51	
					QC 3 - 58	
					QC 3 - 59	
					QC 3 - 68	
					QC 3 - 9	
					QC 3 - 40	
					QC 3 - 19	
					QC 3 - 43	
					QC 3 - 24	
					QC 3 - 61	
					QC 3 - 81	
180	Packaging 3-1 - Stock - B4B	20	10/2/19	0.00	0.00	Packaging 3 - 1 - B4B
		pcs				Packaging 3 - 2 - B4B
						Packaging 3 - 3 - B4B
						Packaging 3 - 4 - B4B
						Packaging 3 - 5 - B4B
						Packaging 3 - 6 - B4B
						Packaging 3 - 7 - B4B
						Packaging 3 - 8 - B4B
						Packaging 3 - 9 - B4B
						Packaging 3 - 10 - B4B
						Packaging 3 - 11 - B4B
						Packaging 3 - 12 - B4B
						Packaging 3 - 13 - B4B
						Packaging 3 - 14 - B4B
						Packaging 3 - 15 - B4B
						Packaging 3 - 16 - B4B
						Packaging 3 - 17 - B4B
						Packaging 3 - 18 - B4B
						Packaging 3 - 19 - B4B
						Packaging 3 - 20 - B4B
						Packaging 3 - 21 - B4B
						Packaging 3 - 22 - B4B
						Packaging 3 - 23 - B4B
						Packaging 3 - 24 - B4B
						Packaging 3 - 25 - B4B
						Packaging 3 - 26 - B4B
						Packaging 3 - 27 - B4B
						Packaging 3 - 28 - B4B
						Packaging 3 - 29 -

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				B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
190 QC 21 - SA	20	10/2/19	0.00 0.00	QC 21 - SA - 21	
	pcs			QC 21 - SA - 70	
				QC 21 - SA - 53	

NOV 08 2019

ST/21F

Part Op 100 - Cut Blank at 4.625"
 Descriptions: 110 - 1-Machine per folio FB168 DWG REV: E FOLIO REV: AT 2- deburr and break all sharp edges
 120 - (QC2- Inspect parts off machine FAI/FAIB)
 130 - (QC8- Inspect parts - second check)
 140 - (Chemical Conversion Coat per QSI005 4.1)
 150 - (QC7-Inspect Chemical Conversion Coat)
 160 - (White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum) START TIME: _____ OVEN TEMPERATURE: _____
 FINISH TIME: _____
 170 - (QC3- Inspect Part Finish)
 180 - (Identify as per dwg & Stock Location: _____)
 190 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6B1.500X2.500	6061-T6 Bar 1.50 X 2.50	7.7200 ft (.386 ea)	100-Bandsaw - 1	5207687

Mater used 7.700

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Bandsaw - 1	M6061T6B1.500X2.500	8	51	0

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Skidtube Clevis	4.430Inches ± 0.030	4.460 4.400		4.428
2	Skidtube Clevis	2.300Inches ± 0.030	2.330 2.270		2.295
3	Skidtube Clevis	1.778Inches ± 0.010	1.788 1.768		1.777
4	Skidtube Clevis	0.880Inches ± 0.030	0.910 0.850		.874
5	Skidtube Clevis	0.510Inches + 0.010 - 0.000	0.520 0.510		.511
6	Skidtube Clevis	1.063Inches ± 0.010	1.073 1.053		1.060
7	Skidtube Clevis	1.380Inches ± 0.030	1.410 1.350		1.380
8	Skidtube Clevis	0.190Inches ± 0.030	0.220 0.160		0.190
9	Skidtube Clevis	0.100Inches ± 0.010	0.110 0.090		.095
10	Skidtube Clevis	0.484Inches + 0.006 - 0.001	0.490 0.483	Diameter	.487
11	Skidtube Clevis	0.500Inches ± 0.030	0.530 0.470		.495
12	Skidtube Clevis	0.640Inches ± 0.030	0.670 0.610		0.635
13	Skidtube Clevis	3.150Inches ± 0.010	3.160 3.140		3.151
14	Skidtube Clevis	1.080Inches ± 0.010	1.090 1.070		1.079
15	Skidtube Clevis	0.688Inches ± 0.010	0.698 0.678		.688
16	Skidtube Clevis	0.397Inches + 0.006 - 0.001	0.403 0.396	Diameter	.397
17	Skidtube Clevis	1.863Inches ± 0.010	1.873 1.853		1.860
18	Skidtube Clevis	0.190Inches ± 0.030	0.220 0.160	Radius	.190
19	Skidtube Clevis	0.130Inches ± 0.030	0.160 0.100	Radius	.130
20	Skidtube Clevis	0.440Inches ± 0.030	0.470 0.410	Radius	.440
21	Skidtube Clevis	0.125Inches ± 0.010	0.135 0.115		.128
24	Skidtube Clevis	0.250Inches ± 0.030	0.280 0.220	Radius	.250
25	Skidtube Clevis	1.050Inches ± 0.030	1.080 1.020	Product	1.049
26	Skidtube Clevis	1.430 ± 0.030			1.423
27	Skidtube Clevis	1.130Inches ± 0.030	1.160 1.100	Product	1.120
28	Skidtube Clevis	0.800 ± 0.030 0.600		Product	0.6
29	Skidtube Clevis	0.810Inches ± 0.030	0.840 0.780	Product	.810
30	Skidtube Clevis	0.060 ± 0.030		Product	.060
31	Skidtube Clevis	0.183Inches ± 0.010	0.193 0.173	Product	.179

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Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

Route update only

NCR No. _____

Job: _____

Part No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐

DEPARTMENT/PROCESS

Skid-tube ☐
Machining ☐
Large Fab ☐

Cross tube ☐
Small Fab ☐
Finishing ☐

Eng. (Non-AW) ☐
Prod. Eng. Coord. ☐
Rec/Store/Packaging ☐

Engineering ☐
Water Jet ☐
Supplier ☐
Quality ☐

Date: _____

Sequence #: _____

QTY Affected: _____

MRB (QS1042)

Description Work Order Deviation

Disposition

Completed By _____

Lead hand / Supervisor _____

QC / QA Coordinator _____

Root Cause

Operator ☐
Manufacturing Process ☐
Equip/Tooling ☐
Handling/Preservation ☐
Material ☐
Product Improvement ☐
Process Improvement ☐
Human Factors ☐

FAULT CATEGORY

Pressure/Forced	Contamination	Power Loss/Surge	Positioned Wrong
Bending	Misaligned/off center	Folio/Program	Outside Tolerance
Crushing	BOM/Route	Grain Direction	Drawing
Cracks	Broken/Damage/Defect	Weld	Finish
Crimp/Kink/Ripple/Wave/Twist	Incomplete/Unclear Instructions	Wrong Stock Pulled	Part Lost/Missing
Marks/Chatter	Drill Holes	Out of Sequence	Misread
Mislabeled	Fit/Function	Off-set/Set-up	

Other/Details: _____